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D3913-041

Job Sheet 197012



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/27/19

Job Tracking No:

Due Date: 7/20/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	7/20/19		0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		DAS
							Large Fab - 5		24
							Large Fab - 6		9-89
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	7/20/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		43
							QC 9 - 50		9-89
							QC 9 - 9		
120	QC 5	1 pcs	7/20/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		DAS
							QC 5 - 43		43
							QC 5 - 49		9-89
							QC 5 - 51		
							QC 5 - 58		

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	7/20/19	0.00	0.29	Handfinish - 2 - 1 - B4B	BFB 19-09-10
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White GI(S)-B4B	1 pcs	7/20/19	0.00	0.93	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BR 19-9-10.
						Powdercoat - 4 - B4B	
140	QC 3	375 ¹ pcs	7/20/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	HL 19-9-10
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	7/20/19	0.00	0.50	Handfinish - 4 - 1 - B4B	HL 19-9-11
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	

DAS
15
9-89

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180 QC 21 - SA		1	7/20/19	0.00 0.00	Packaging 3 - 36 - B4B	
		pcs			QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - Weld per dwg A/R S.S. rod Batch: <u>N170844</u> - assemble ribs , weld as per dwg D3913 using DT9610A ***inspect Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg 110 - QC9- Inspect visual per QSI004- Fusion Welds 120 - QC5- Inspect part completeness to step on W/O 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat 140 - QC3- Inspect Part Finish 150 - Assemble as per dwg - Pick Kit 160 - QC5- Inspect part completeness to step on W/O 170 - Identify as per dwg & Stock Location: 180 - QC21- Final Inspection - Work Order Release						

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5188852
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5190438
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5184576
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5787025140730
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5197553
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5190825
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5204375
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5203884
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5188922
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5183658
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5197557
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5205882
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5192406
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5204825
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5197525
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211019
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5184342
AN3-10A	Bolt	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5149261
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	586432
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5196541
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5149291
NAS1149F0332P	Washer (AN980-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5158171
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5188988
NAS1149FN832P	Washer (AN980-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136569

Pas allocate, Besoin de D4672-1
(Blanking plate)

011551

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	58	0
	D3913-1	1	10	0
	D3913-15	1	25	0
	D3913-3	1	10	0
	D3913-7	2	14	0
	D3913-9	1	13	0
	D3916-041	2	13	0
	D3916-5	3	11	0
	D4016-1	3	43	0
	D4017-7	3	55	0
	D4017-9	2	14	0
	D4020-11	2	6	0
	D4021-1	3	43	0
	D4034-041	1	3	0
	D4034-043	1	3	0
	D4672-1	2	15	0
	M304EX0.75-16F	32	876	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	203	0
	D2931	2	699	0
	D4021-5	2	42	0
	MS20600-AD4W3	2	440	0
	MS21042L3	6	1,363	0
	NAS1149F0332P	12	2,775	0
	NAS1149FN832P	2	2,462	0
Part Specifications				
Specifications could not be found.				

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